

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009903**Date Inspected:** 20-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** T. Imai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking, and Deviation Saddles**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Art Peterson was present during the times noted above for observations relative to the work being performed in Fabrication Shop #4 and the Foundry Shop at Japan Steel Works.

Fabrication Shop #4:

Dismantling of Segments in-process after the Trial Assembly Survey: West Deviation Saddle Segments - East Side

The QA Inspector observed the JSW personnel were in-process on dismantling west deviation saddle segments W2-E1, W2-E2, and W2-E3. The JSW personnel have completed the trial assembly survey on assembled west deviation saddle segments W2-E1, W2-E2, and W2-E3. The QA Inspector also performed a random dimensional verification inspection on the assembled west deviation saddle segments prior to the segments being dismantled. See photos attached to this report for reference to the QA dimensional verification inspection. The JSW Representative Mr. Hideaki Kon informed the QA Inspector that JSW will prepare the dimensional inspection report this week and afterwards submit a copy of the report to the Engineer for review.

Final Dimensional Inspection in process on Saddle: West Deviation Saddle Segment W2-W1

The QA Inspector observed that the JSW personnel have started the dimensional inspection on west deviation saddle segment W2-W1 of the machined base plate, machined surfaces inside of the trough, the tie rod and anchor bolt holes, the connection bolt holes on the end rib plates, and the machined surfaces on the end rib section that mates to west deviation saddle segment W2-W2. The dimensional inspection is being performed by an independent third party hired by JSW. The equipment being used is a 3D Laser tracking device manufactured by Leica. The QA Inspector was informed by JSW Representative Mr. Hideaki Kon that the dimensional inspection

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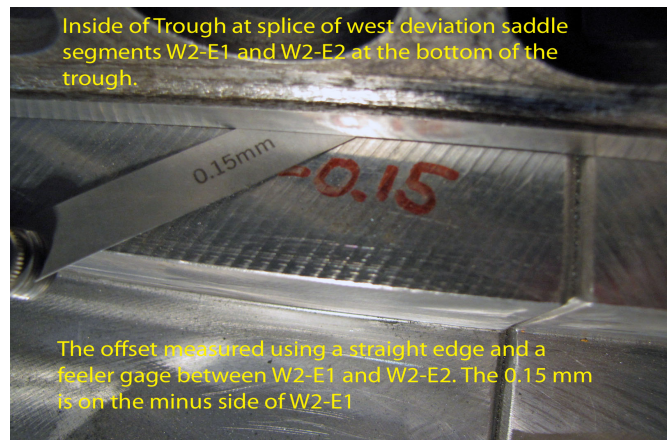
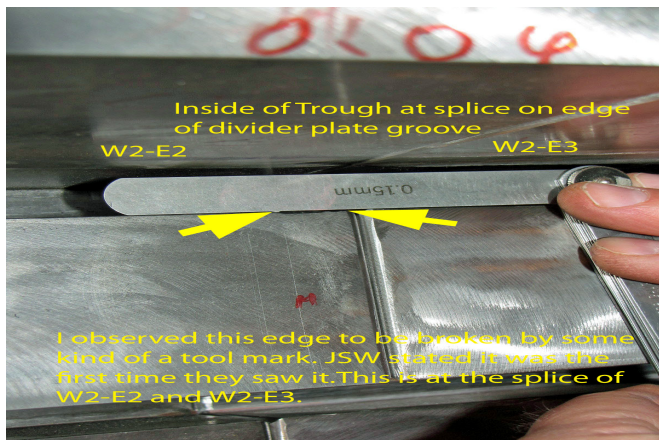
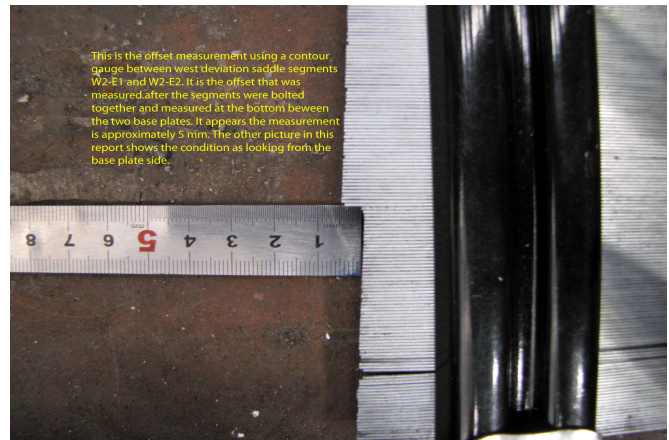
will be completed in approximately 2 days. The QA Inspector observed that the dimensional inspection was in process at the end of the QA Inspectors' shift.

Foundry Shop:

Grinding Operation in-process on Saddle: West Jacking Saddle

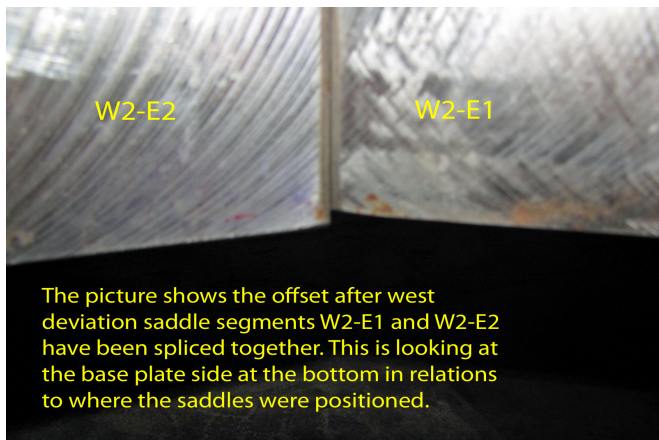
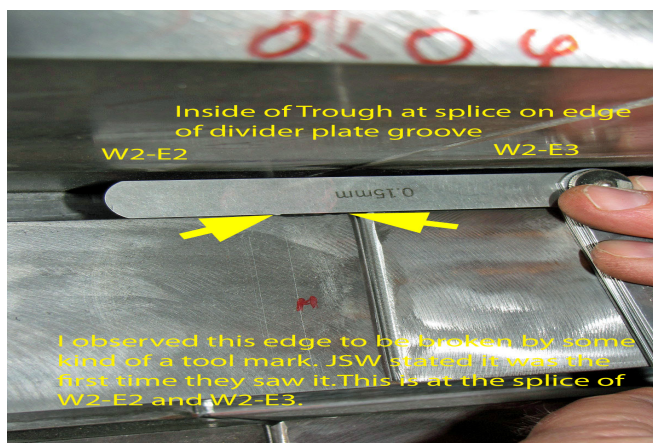
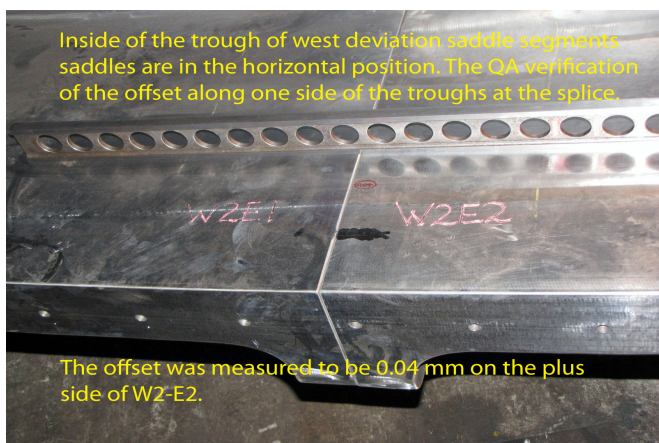
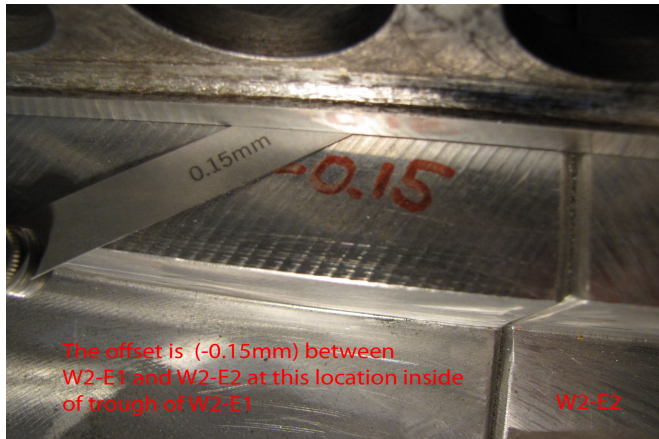
The QA Inspector observed (1) JSW personnel was in process performing the grinding operation on the major excavation and minor excavation repair welds previously performed on the west jacking saddle. The purpose of the JSW personnel performing the grinding operation is to grind the repair welds to an acceptable profile in accordance with ASTM A802 surface quality category (J) - (metal removal marks- welds) to a visual quality level (3). The QA Inspector observed that the grinding operation was still in-process at the end of the QA Inspectors' shift.

Unless otherwise noted in this report, all observations reported on this date appeared to be in general compliance with the applicable contract specifications.



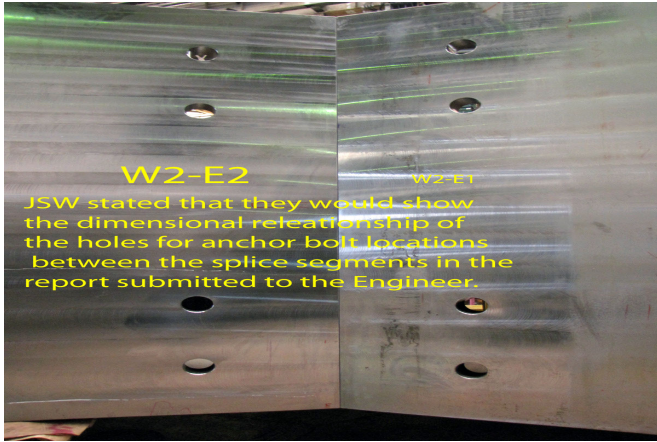
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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy at (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Peterson, Art	Quality Assurance Inspector
Reviewed By:	Edmondson, Fred	QA Reviewer
